



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3197-041
Job Sheet 190127



008451

Part No: D3197-041

Job Qty: 8 pcs

Part Name: Bar



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No:

Due Date: 3/15/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV B IPP Rev: A New Issue 05-11-08 JLM IPP Rev: B As per Rev B 06-03-10 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs		3/15/19	0.00	0.70	Bandsaw - 1		mmL 19/02/19
110	HAAS 4 Axis - B4B	8 pcs		3/15/19	0.51	5.93	HAAS - 1 - B4B		
							HAAS - 2 - B4B		mmL 19/02/19
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	8 pcs		3/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		mmL 19/02/19
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		



Container No: S154361



Part: D3197 - 041

Job No: 190127

Serial No/Batch: S154361

Revision: 1

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/15/19

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					QC 2 - 56	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
130	Conventional Lathe - 1 - B4B	8 pcs	3/15/19	0.00 1.41	Conventional Lathe - 1 - B4B	
					Conventional Lathe - 2 - B4B	mml 19/02/23
140	QC 8	8 pcs	3/15/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B = 19-02-23
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
150	Handfinish - 1-1 Chemical-B4B	8 pcs	3/15/19	0.00 0.69	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/2/25
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	Powdercoat - 3 Grey Sand - B4B	8 pcs	3/15/19	0.00 0.35	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	B/L 19-02-25
START: 2:25 Q.U.T: 300° FINISH: 2:55						
170	QC 3	8 pcs	3/15/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	

Entered: _____ Date: _____



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Other/Details:					

				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	DAS 40
				QC 3 - 68	DAS 9
				QC 3 - 9	9-89 9-89
180	Small Fab - 2 - B4B	8 pcs	3/15/19	0.00 2.05	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
190	QC 5	8 pcs	3/15/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 38
					QC 5 - 42
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
200	Packaging 3-1 - Stock - B4B	8 pcs	3/15/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B

DAS 40
9-89

SMP

DAS 9
9-89

19/04/26

DAS 40
9-89

MAR 07 2019

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Other/Details:					

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	8266 MAR 13 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
210 QC 21 - SA	8	3/15/19	0.00 0.00	QC 21 - SA - 21	MAR 13 2019 BAS 70 9-89
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blanks: 29.125" long

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Face ends to length per dwg D3197 2-Machine D3197-1 as per Folio FA340 and Dwg D3197

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (Manufacture as per dwg) Chamfer as per Dwg D3197

140 - (QC8- Inspect parts - second check)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Small Fab) Assemble D3197-041 as per Dwg D3197

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73R1.000	7075-T73 Round Bar 1.00	19.3600 ft (2.42 ea)	100-Bandsaw - 1	S100175
D2690-5	Lanyard Assembly	16 pcs (2 ea)	180-Small Fab - 2 - B4B	S014617
D3242-1	Tag	16 pcs (2 ea)	180-Small Fab - 2 - B4B	S152492 X15
D3489-3-200	Pip Pin	16 pcs (2 ea)	180-Small Fab - 2 - B4B	S154623 X15
MS21042L3	Nut	16 Ea (2 ea)	180-Small Fab - 2 - B4B	S009962 V1
MS27039-1-24	Screw	16 Ea (2 ea)	180-Small Fab - 2 - B4B	S130347
NAS1149D0363J	Washer	48 Ea (6 ea)	180-Small Fab - 2 - B4B	Fm134537-10
				S123436

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73R1.000	19	24	0
180-Small Fab - 2 - B4B	D2690-5	16	5	0
	D3242-1	16	9	0
	D3489-3-200	16	7	0
	MS21042L3	16	2,782	0
	MS27039-1-24	16	126	0
	NAS1149D0363J	48	856	0

Part Specifications

Specifications could not be found.

Plex 2/5/19 11:04 AM dart.white.jesse

Entered: _____ Date: _____



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